



## MODEL CH2420A CHEEK BENDER

### OPERATION, PARTS & MAINTENANCE MANUAL

<b>Model:</b>	<b>Purchased From:</b>
<b>Serial #:</b>	<b>Date Received:</b>

**USA  MADE**  
*An American Tradition Since 1910*

Roper Whitney / 2833 Huffman Blvd. / Rockford, IL 61103 / 815-962-3011 / Fax 815-962-2227  
[www.roperwhitney.com](http://www.roperwhitney.com)

## **FOREWORD**

This manual has been prepared for the owner and operators of Roper Whitney CH2420A Cheek Bender. Its purpose, aside from operations instructions, is to promote safety through the use of accepted operating procedures. Read all instructions thoroughly before operating the bender.

Also contained in this manual is the parts list for your Cheek Bender. It is recommended that only Roper Whitney or factory authorized parts be used as replacements.



Warranty Statement:

### **3 YEAR LIMITED WARRANTY**

Roper Whitney ("Manufacturer") warrants, commencing with the date of shipment to first end-user ("Customer") and for a period of thirty-six (36) months thereafter, all machinery and parts manufactured by Manufacturer to be free of defects in workmanship and material. **This warranty remains in force for the above time period only if all of Manufacturer's operational procedures are followed and recommended maintenance is performed.** If, within such warranty period, any machinery or parts manufactured by Manufacturer shall be proved to Manufacturer's satisfaction to be defective, such machinery or parts shall be repaired or replaced, at Manufacturer's option. All warranty claims are made F.O.B Manufacturer's plant, providing such machinery or parts are returned freight prepaid to Manufacturer's plant or designated service center for Manufacturer's inspection. All failed parts or components must be returned to Manufacturer prepaid for inspection before credit will be issued for new parts or components. Manufacturer's obligation hereunder shall be confined to such repair or replacement and does not include any charges, direct or indirect, for removing or replacing defective machinery or parts. No warranty shall apply to machinery, or parts or accessories, which have been furnished, repaired, or altered by others so as, in Manufacturer's judgment, to affect the same adversely or which shall have been subject to negligence, accident or improper care, installation, maintenance, storage, or other than normal use or service, during or after shipment. No warranty shall apply to the cost of repairs made or attempted outside of Manufacturer's plant or designated service center without Manufacturer's authorization. No warranty shall apply with respect to machinery or part not manufactured by Manufacturer, including but not limited to motors, accessories, electrical and hydraulic components, if such machinery or part is subject to warranty by the manufacturer of such machinery or part. No warranty claims by Customer will be honored with respect to any machinery or part from which the name and date plate has been removed or is otherwise no longer located or exhibited on such machinery or part. **THE FOREGOING WARRANTIES ARE IN LIEU OF ALL OTHER WARRANTIES EXPRESSED OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY AND IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE. MANUFACTURER SHALL NOT BE SUBJECT TO ANY OTHER OBLIGATIONS OR LIABILITIES WHATSOEVER WITH RESPECT TO MACHINERY, PARTS, ACCESSORIES, OR SERVICES MANUFACTURED OR FURNISHED BY IT OR ANY UNDERTAKINGS, ACTS, OR OMISSIONS RELATING THERETO. UNDER NO CIRCUMSTANCES SHALL MANUFACTURER BE LIABLE FOR ANY CONSEQUENTIAL OR OTHER DAMAGES, EXPENSES, LOSSES, OR DELAYS HOW SO EVER CAUSED.**  
**THERE ARE NO WARRANTIES THAT EXTEND BEYOND THE DESCRIPTION ON THE FACE HEREOF.**

**Note: Consumable tooling is not covered under the 3 year manufacturer's warranty.**

Opening rolls are a consumable and not subject to warranty.

RETURN OF THE PRODUCT REGISTRATION CARD FURNISHED WITH THE PRODUCT IS NECESSARY TO OBTAIN WARRANTY COVERAGE THEREON. CARD MUST BE FULLY COMPLETED, SIGNED BY THE PURCHASER, AND IF APPLICABLE, SIGNED BY THE DISTRIBUTOR. RETURN REGISTRATION CARD TO:

Roper Whitney 2833 Huffman Blvd. Rockford, IL 61103  
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[www.roperswhitney.com](http://www.roperswhitney.com)

## **SAFETY RULES**

### **CH2420A CHEEK BENDER**

1. Keep the work area well lighted, clean, neat, and orderly to avoid accidents. Do not use compressed air for cleaning debris or grit from yourself or the machine. Remove debris and grit from machine with a rake or brush - not your hands.
2. Machine to be operated by authorized personnel who have been trained by their supervisor with the working and safety features of the machine, and by reading and understanding the Operator's Manual as well as the warnings and instructions mounted on the machine.
3. Use hoists and cranes to lift heavy machine units, workpieces, or any other load too heavy for one person. Never use a crane, hoist, or other lifting device to lift more than its rated capacity. Be sure loads are balanced.
4. Use safety glasses and required protective tools.
5. Do not wear loose, hanging clothing or jewelry while operating or servicing the machine. Gloves, if worn, should be snug fitting so they won't be snagged by moving equipment.
6. Notify your supervisor whenever you feel there is a hazard involving the equipment or the performance of your job.
7. Report all injuries or illness, regardless of severity, to your supervisor.
8. Do not place speed above safety.
9. Never use a machine or tool for anything other than its intended purpose. Use the proper tool and equipment for the task.
10. Do not remove, paint over, alter, or deface any machine-mounted warning and instruction plates and signs.
11. Do not override the safety features of the equipment.
12. Do not operate the machine in excess of its rated capacity.
13. Beware of protruding machine elements or assemblies. Avoid any pinch-points created by the movement of the machine's components.
14. Inspect the machine before each use to ensure that it is in proper working condition. Check for cracks, chips, burrs, and other evidence of failure.
15. Report any damage to the machine to your supervisor.
16. Use only approved cleaning fluids.

## **SPECIFICATIONS**

Produces bends up to 24 inches. A two-way trunnion, that keeps the bending bar in position at the starting point, also assures perfect bends throughout the entire length. Adjustable plate can be set for bends of 3/16 inch to 5/16 inch widths. Capacity, 20 gauge. (Spacers available for lighter gauge work on request.) Shipping weight, 96 lbs.

### **Specifications:**

Capacity: 20 Ga. Mild Steel x 24

Dimensions: 32" L x 18" W x 7" H (96 lbs.)

### **Mounting Unit:**

Place Cheek Bender unit in a position on the worktable so that sufficient clearance is available for bending the maximum size section. Be sure unit is placed so that open end overhangs the table. When unit is in the most desirable work position, fasten unit to work table or bench with lag screws provided. Place handles into pivot bar holes and lock into place with Allen head set screws.

### **To Change Flange Height:**

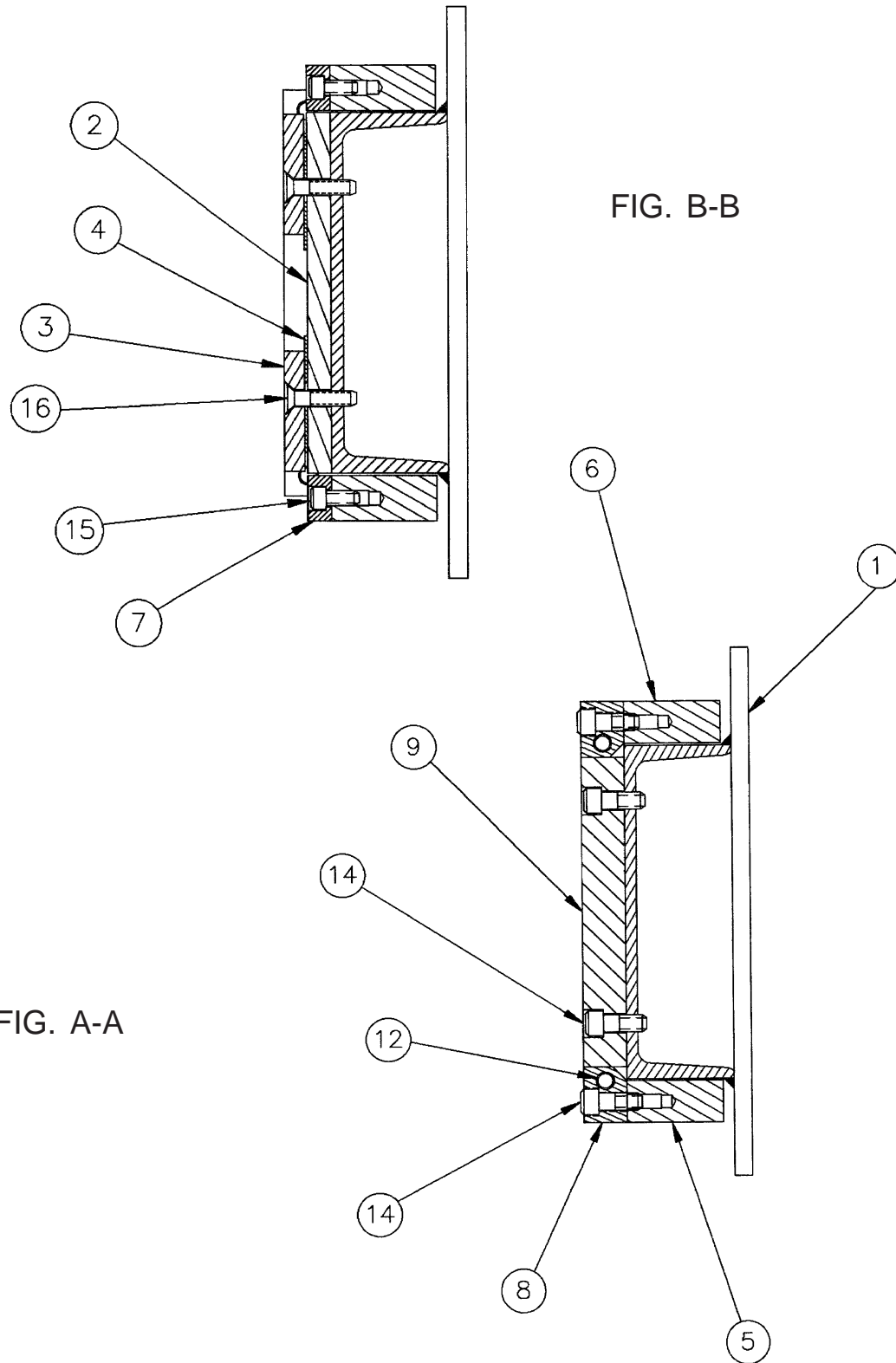
The shims are set at the factory to run a flange of 3/16 inch. This dimension can be changed in the following manner. Remove the 4 hex head bolts on the top plate and change to desired dimension. The adjustable shim will give a range of 3/16 to 5/16 of an inch. This procedure may be done on left and right top plates, if desired.

### **For Lighter Gauge Work:**

Shims are also available, upon special request, for lighter gauge forming. When ordering shims, please give maximum gauge and range to be run. (Shims for 20 gauge are standard from the factory.)

# **CH2420A CHEEK BENDER**

## **PARTS IDENTIFICATION**



# CH2420A CHEEK BENDER

## PARTS IDENTIFICATION

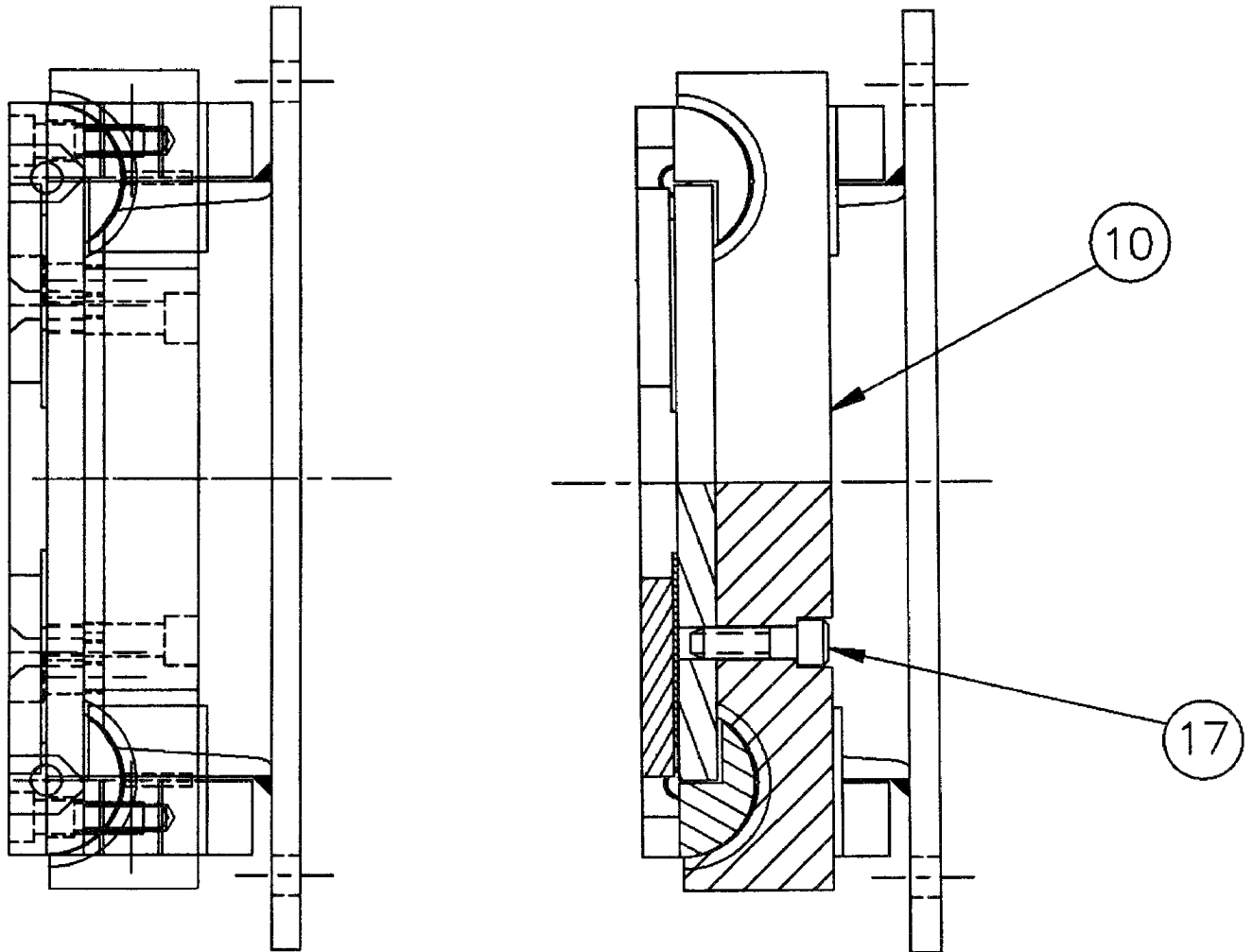


FIG. C-C

Technical drawing of a mechanical assembly, likely a mold or press, showing a top view. The drawing includes a central rectangular frame with four vertical supports (11) and four horizontal supports (12). A central rod (13) is shown passing through the frame. The frame is secured by four corner brackets (14) and four corner nuts (15). A central rod (16) is shown passing through the frame. The drawing is labeled with 'A', 'B', and 'C' indicating different views or sections. A small label '21' is located near the bottom left corner.

## **CH2420A CHEEK BENDER**

### **PARTS LIST**

<b>ITEM</b>	<b>PART NUMBER</b>	<b>PART NAME</b>	<b>QTY.</b>
1	768060035	Base	1
2	768060036	Bottom Plate	1
3	768060037	Top Plate	2
4	768720044	Shim	2
5	768030038	Pivot Bar, L. H.	1
6	768030039	Pivot Bar, R. H.	1
7	768030040	Pivot Bar Leaf	2
8	768500041	Pivot Hinge	4
9	768500042	Pivot Hinge Bar	2
10	768060048	Trunnion Plate	1
11	768060014	Handle	2
12	600053332	Dowel Pin 5/16 x 1 1/2	4
13	649023009	Hex Jam Nut 5/8-11	2
14	611012131	SHC Screw 5/16-18 x 3/4	8
15	611012086	SHC Screw 1/4-20 x 1/2	8
16	613012091	FSHC Screw 1/4-20 x 1.0	8
17	611012133	SHC Screw 5/16-18 x 1.0	2
18	600366507	Allen Wrench 3/16 (not shown)	1
19	600366509	Allen Wrench 1/4 (not shown)	1
20	768000045	Shim Adjustment Tool (not shown)	1
21	600346122	Name Plate, Model and Serial Number	1
22	668356353	Vinyl Grip	2